

# Work Order ID 85507

June-08-12 2:45:45 PM

**\*85507\***

Page 1

Item ID: D206-651-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: 206A/B GHW

Stop **\*NS2\***

Start Date: 08/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/08

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2711/D2690

Rev A/B2

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-651-041 CHG001

*5/2/04/06*

*OK for ch 12/7/06*

110

0.00

**\*110\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut two cable CBL-1240 per assembly (10.75" each) Remove 2.25" of sleeve from each end of cable CBL-1240-Crimp CBL-460 onto CBL-1240 to make (2) D2690-8 as per Dwg D2690. (Leave one end open)3-Install Lanyard D2690-8 (from open end) into pin D2711 a

*4x*

*12/07/05*

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*5/2/04/05*

*(4)*

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Page 2

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Item Name: 206A/B GHW

Start Date: 08/06/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-651-041 CHG001 Location: <u>125</u> PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*12/7/10*

*CK 12/7/10*

*MF 12-07-09*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

**FAULT CATEGORY**

Landing Gear	Hardware	General	Maintenance
<input type="checkbox"/> Bending Passes Below Min	<input type="checkbox"/> Breaking	<input type="checkbox"/> Burrs	<input type="checkbox"/> Set-up
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Missing	<input type="checkbox"/> Contamination	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Cracks	<input type="checkbox"/> Size/Length	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Off-Set
<input type="checkbox"/> Crushed/Crimp at Bending	<input type="checkbox"/> Spinning	<input type="checkbox"/> Documentation/Data	<input type="checkbox"/> Orientation Misread
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Threading	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Other	<input type="checkbox"/> Wrong	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Inspection Unqualified	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ripples on Inner Bend	<b>Drill Holes</b>	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Misaligned	<input type="checkbox"/> Jigs/Fixtures/Tooling	<input type="checkbox"/> Part Lost
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Kit Incorrect	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Over/Undersized	<input type="checkbox"/> Kit Missing	<input type="checkbox"/> Raw Material
	<input type="checkbox"/> Too Many		<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

# Picklist Print

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Work Order ID: 85507

**\*85507\***

Parent Item: D206-651-041

**\*D206-651-041\***

Parent Item Name: 206A/B GHW

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev: F 02.08.14 Re-format KJ

IPP Rev: G Removed Purchasing 07-03-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10

NAS1149D0363J

Purchased

No

**\*AN960JD10\***

Washer

CBL-1240

Purchased

No

**\*CBL-1240\***

Cable

### Location

### Loc Qty

### Loc Code

GA

385.681659

113565

3.911789

119021

368.73647

119690

13.0334

CBL-460

Purchased

No

**\*CBL-460\***

Loop Sleeve

### Location

### Loc Qty

### Loc Code

GA

786

121574

786

D2692

Manufactured

No

**\*D2692\***

Spring Pin Clip

### Location

### Loc Qty

### Loc Code

ST016

169

74121

169

\*\*

\*\*

\*\*

\*\*

16

7.52

16

4

4

9/5/12/07/05

9/5/12/07/05

9/5/12/07/05

9/5/12/07/05

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

**FAULT CATEGORY**

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<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Missing	<input type="checkbox"/> Contamination	<input type="checkbox"/> Supplier
<input type="checkbox"/> Cracks	<input type="checkbox"/> Size/Length	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crushed/Crimp at Bending	<input type="checkbox"/> Spinning	<input type="checkbox"/> Documentation/Data	<input type="checkbox"/> Weld
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Threading	<input type="checkbox"/> Finish	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Other	<input type="checkbox"/> Wrong	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Inspection Unqualified	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Ripples on Inner Bend		<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Torque Waves in Extrusion		<input type="checkbox"/> Jigs/Fixtures/Tooling	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Turning Sequence		<input type="checkbox"/> Kit Incorrect	<input type="checkbox"/> Part Lost
<input type="checkbox"/> Wave/Twist in Tube		<input type="checkbox"/> Kit Missing	<input type="checkbox"/> Part Moved
			<input type="checkbox"/> Raw Material
			<input type="checkbox"/> Other

# Picklist Print

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Work Order ID: 85507

\*85507\*

Parent Item: D206-651-041

\*D206-651-041\*

Parent Item Name: 206A/B GHW

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2711

Manufactured No

Each

130.0000

\*D2711\*

Lock Pin

\*\*

4  
8/12/07/05

Location

Loc Qty

Loc Code

ST016

47

79559

47

ST029

83

76581

83

MS21042L3

Purchased

No

Each

2,027.000

\*MS21042L3\*

Nut

\*\*

4  
8/12/07/05

Location

Loc Qty

Loc Code

ST300

2027

115835

4

117885

32

119017

900

119075

138

121349

143

121444

810

MS27039-1-08

Purchased

No

Each

1,437.000

\*MS27039-1-08\*

Screw

\*\*

8  
8/12/07/05

Location

Loc Qty

Loc Code

ST291

1437

117423

81

119075

1

120308

312

121011

43

121243

500

121708

500

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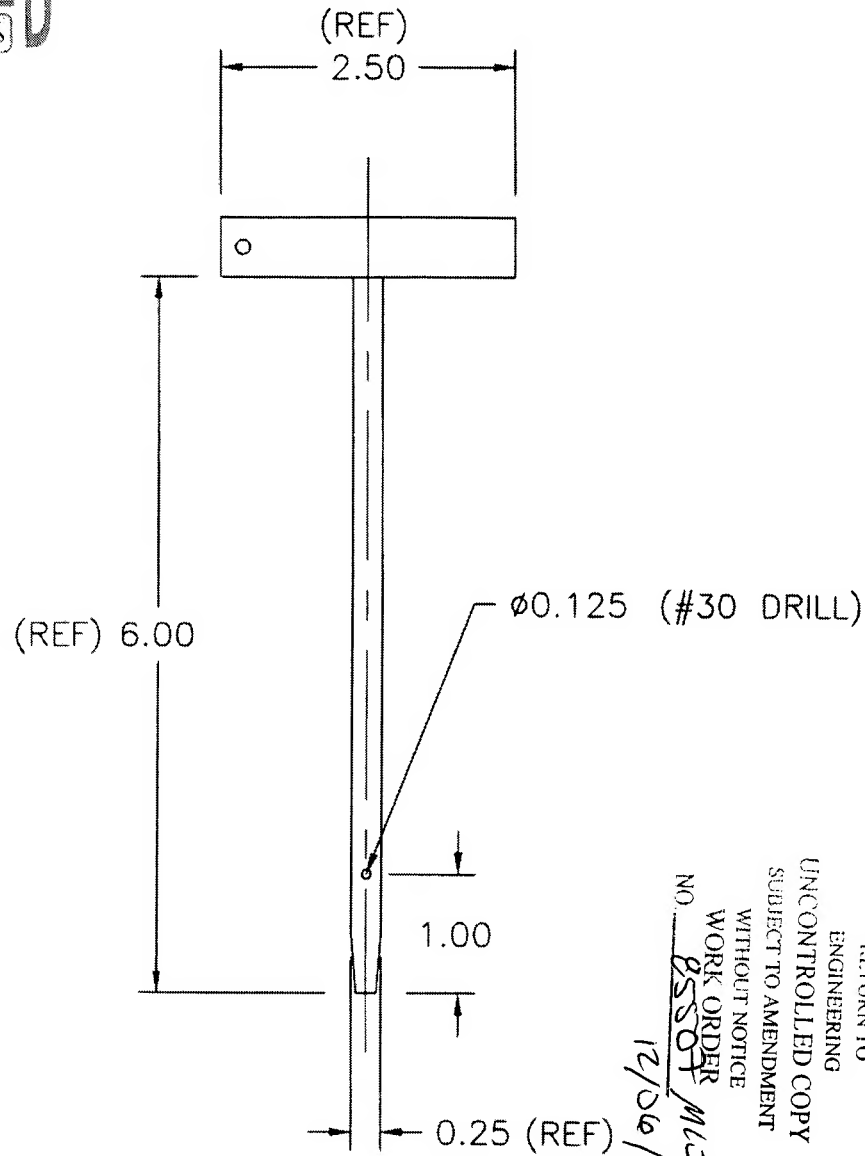
Shop Packet Print

Page 2



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2711	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LOCK PIN	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED  
97/11/06 DS



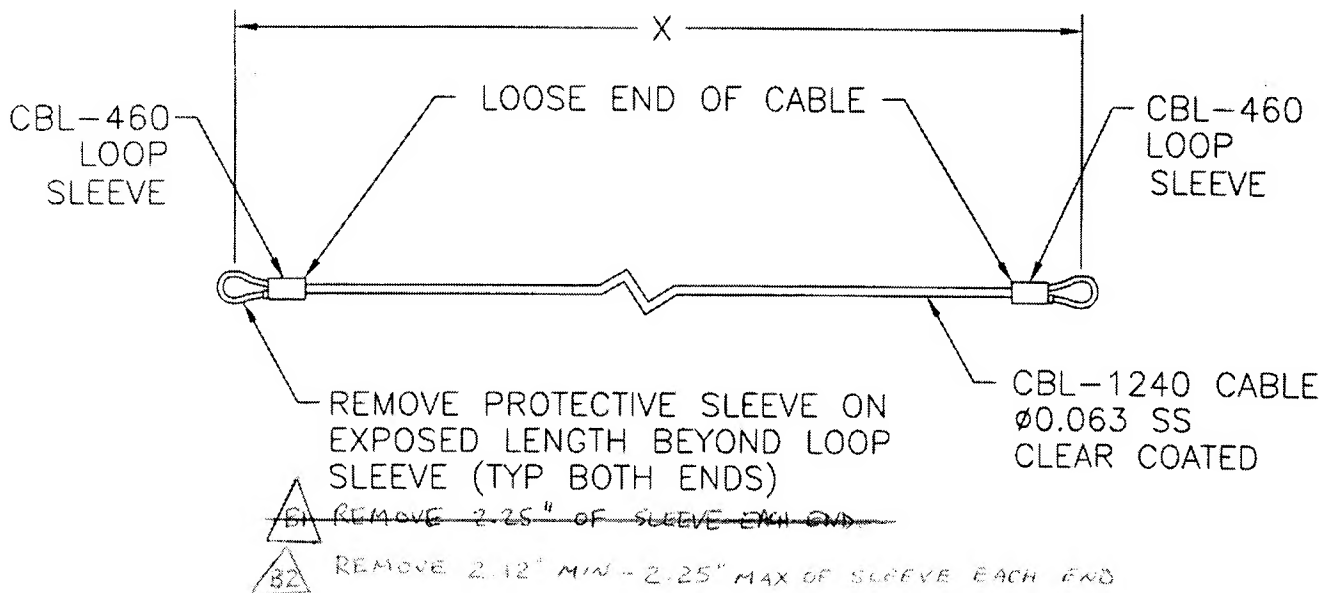
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85507/MC  
12/06/08

MAKE FROM REID TOOL SUPPLY PART # PNT-9  
FINISH: CAD PLATE



DESIGN <i>MEY</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MEY</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	<del>IP</del> 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	<del>IP</del> 04.06.24	ADDED TOLERANCE	

RELEASED  
971003 KE  
FOR A374



D2690-X

X = LENGTH IN INCHES

NOTE: CUT CABLE 2.50\* INCHES LONGER THAN 'X' LENGTH.  
FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH  
SLEEVE AT END OF LOOSE END OF CABLE WITH  
CBL-705 CRIMPING TOOL.  
\*ADDITIONAL LENGTH MAY BE NECESSARY IN  
SOME APPLICATIONS. CUT AS REQUIRED.

NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER  
ASSEMBLY WITH ATTACHING PARTS.

ASTC

DEO's